### Work Order ID 53782

November 18, 2009 12:38:59 PM

Quality Control



Page 1

Accept D2230-1 Setup Start Item ID: **Revision ID:** Stop Item Name: Lug 18/31/2009 Start Qty: 120.00 **Start Date:** Cust Item ID: Required Date: 25/71/2009 Req'd Qty: 120.00 **Customer:** Reference: Start Run Date: 04/4/8 Tooling: Date: Approvals: Stop SPC (Y/N): Date: Date: Sequence ID/ Set Up/ Draw Draw Plan Accept Reject Reject Insp. Operation Work Center ID Description Number Rev. Code Qty Qty Number Stamp **Run Hours Draw Nbr Revision Nbr** D2230 Rev F 0.00 100 BAND SAW ont oglilas 120 Bandsaw Memo Cut D2423 extrusion to 0.82" Batch: 43722 Jeaspa Bandsaw 110 120 HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine per folio D2230-1 ☐ (Check for crack while loading into the HAAS CNC vertical machine #1 machine.) 2-Tumble and deburr rough edges after tumbling 0.00 Brog/11/25 QC2- Inspect parts off machine FAI/FAIB 120 120 0.00 / Memo QC

Dart	<b>Aerospa</b>	ace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector					
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			,									

Part No: <u>ルムとろ</u>	<u>○ - \</u> PAR #:	Fault Category: <u>Uமரிப்பரி</u> ம	AS NCR: (es) No	DQA:	_ Date: _₫	55.12.11
Resc	olution: <u>Scrap</u>	Disposition:SCNAP	QA: N/C Closed	: <i></i>	Date:	2.12.11
NCR:53782	•	WORK ORDER NON-CONFO	RMANCE (NCR)			
	Description of NC	Corrective Action	Section B	orification	Annroyal	Annessal

		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval : Chief Eng	QC Inspector
9/11/27	110	7 pieces too thin on the 0.306 dain. Jig did not support the by preparely		Ecrap and destroy replace Qty 7 B 43722	og/11/27	9/11/30		hez.11-3
		R.C. proces/tooling	LOSIUZ	madified the sister support		,	poskum	107.11
			posium	cline to correct the 135me! lead line/setup.			POSIMZ	603.11-5
		1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1				!		

140

HandFinish

Quality Control

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

MD 09/11/30

X120

Page 2

Insp.

Stamp

150

Quality Control

QC3- Inspect Part Finish

Memo

Memo

0.00

0.00

0.00

BR 09-11-30

W/O:			V	ORK OR	DER CHA	NGES	•				<u> </u>
DATE	STEP	PROCI	EDURE CH	IANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:		NCF	R: Yes	No DQA	:	Date:	
	R	esolution:	Disposit	ion:		QA:	N/C Cld	sed:		Date: _	
NCR:				DER NON						· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Correctiv Acti	e Action on Descripti Chief Eng	Section B on	Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
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				·	· · · · · · · · · · · · · · · · · · ·						``



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November 18, 2009 12:38:59 PM D2230-1 Item ID: Accept Setup Start F **Revision ID:** Stop Item Name: Lug Start Oty: 120.00 **Start Date:** 18/11/2009 Cust Bem ID: Req'a Qty: 120.00 **Required Date: 25/11/2009 Customer:** Reference: Run Start Date:\_\_\_\_\_ Tooling: Approvals: Process Plan: Date: Stop oć: SPC (Y/N): Date: \_\_\_\_\_ Date: Sequence ID/ Operation Set Up/ Reject Draw Draw Plan Accept Reject Insp. Number Stamp **Work Center ID** Description **Run Hours** Number Rev. Code **Qty** Qty 160 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 K09-11-30 0.00 Powdercoat OVEN TEMPERATURE: START TIME: Powder Coating W 09/12/01 QC3- Inspect Part Finish 170 X120 0.00 QC, Memo Quality Control Identify as per dwg & Stock Location: 5+476 0.00 180 80/21/160 am XIAO 0.00 Packaging Memo Packaging

W/O:	/O:		WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									·
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	A:	_ Date:	
	Res	solution:	Disposition	:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	1)			
DATE	STEP	Description of NC		Corrective Action Section		1	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
			:						

#### Work Order ID 53782

F

Lug



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November 18, 2009 12:38:59 PM

**Required Date: 25/11/2009** 

Item ID:

D2230-1

Accept



Setup Start



Stop



**Revision ID:** Item Name:

18/11/2009

QC:

Start Qty: 120.00 Req'd Qty: 120.00

Operation

Description

Cust Item ID:

**Customer:** 

Reference:

**Start Date:** 

Approvals:

Process Plan:

Date:

Date: Tooling:

Date:

Date:

Start

Run

Stop

Sequence ID/

**Work Center ID** 

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**  Draw Number Draw Plan Code Rev.

Accept Qty

Reject

Reject Insp.

190

0.00

**SPC (Y/N):** 

Qty

Number Stamp

Quality Control

Memo

0.00

	•									
W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes I	No <b>DQ</b>	<b>A</b> :	_ Date: _	1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -
	Res	solution:	Disposition	n:	QA: N	VC CIO	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE (	NCR	)			
DATE	STEP	Description of NC	Corrective Action Section			Cian 0	Verific		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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1										

### **Picklist Print**

November 18, 2009 12:39:05 PM

Work Order ID: 53782

D2230-1RevF Parent Item:

Parent Item Name: Lug

Comments:





45800

Start Date: 18/11/2009

**Required Date: 25/11/2009** 

Start Qty: 120.00

Required Qty: 120.00

									•			d.
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-1PRevF		Purchased MF	00/ - 1	12-08		100	Each	0.0000	120.0000			
LUG D2423RevB1		Manufacture	d No			110	f	658.2039	8.6274			
Lug Extrusion												

<u>Warehouse</u>	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	658.2039221	
43722	207.263091	
44529	22.39	

428.550832

8.6274 on Loalul 23

Page 1

	•									
W/O:		,	WC	RK ORDER CHANG	ES		<u>,                                      </u>	<del>,</del>		
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•										
;										
Part No	:	PAR #:	Fault Cate	gory:	_ NCR	: Yes 1	No DQ	A:	Date:	
	Res	solution:	Disposition	າ:	_ QA:	N/C Clo	sed:		Date:	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC			ion B	C: 0	Verific		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	-	Sign & Date	Secti	on C	Chief Eng	QC Inspector
										-
									·	
				U04800						
					,					

DART AEROSPACE LTD	Work Order:	53782
Description: Mounting Lug	Part Number:	D2230-1
Inspection Dwg: D2230 Rev: F	·	Page 1 of 1

	FIRS <sup>-</sup>	Γ ARTICLE II	NSPECTI	ON CHE	ECKLIST		
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		omments
4.450	+/-0.010	4.450	1				
0.306	+/-0.010	.304					
0.345	+/-0.010	.348					
0.400	+/-0.010	.400	/				
0.250	+/-0.010	.250	/				
3.700	+/-0.010	3.700	1				
0.750	+/-0.010	.749					
Ø0.257	+0.005/-0.000	.259					
1.91	+/-0.010	1.915					
R1.200	+/-0.010	1.200	/				
0.375	+/-0.010	.375		-			
		<u> </u>					
				,			
Measured by:	88	Audited by:	الد .	F	Prototype Ap	pproval:	N/A
Date:	9/11/25	Date:	09/11/30			Date:	
Rev Date	Change					Revised b	Tanker Company
A 03.11.11	New Issue					<u>لخي KJ/RF</u>	Y TT

5 3 SHOPE RETUR ENGIN. 1 - 1 UNCONTROLL SUBJECT TO A ... WITER С D2230-1 D2230-3 **D2230-3 MOUNTING LUG D2230-1 MOUNTING LUG** REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION. AJS 09.01.16 REDESIGN; R1.200 WAS 1.100 99.12.13 F CP RE-DESIGN BW 95.01.04 įΕ RE-DESIGN BW 95.01.04 D <u>@</u> RE-DESIGN BW 94.03.30 С NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED DATE REV. DESCRIPTION BY DESIGN BW DART AEROSPACE LTD Α DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. G A) UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS D2230 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE OF 0.015±0.005. 7) WEIGHT: -1: 0.16 lbs **MOUNTING LUG** NTS DE APPR. COPYRIGHT © 1994 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFEDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION OF TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON. DATE -3: 0.14 lbs 09.01.16 3



